

Work Order ID 68855

Thursday, April 21, 2011 12:36:13 PM



Page 1

Item ID: D3589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: LATCH ASSEMBLY

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004

ensure parts fit correctly on jig

A/R Stainless Steel Rod Batch: M 114509

EL 11-10-25

(X1)

Pho →

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PL 11-10-25

(14)

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3589-3-7-041 PAR #: N/A Fault Category: Large FAB NCR: (Yes) No DQA: 11 Date: 11.10.28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/10/31 Date: 11/10/31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/25	#100	welder scrapes D3589-043 when welding due not re checking to Des. R.C. LOA.	S QS7042 11/10/25	Scrap + Destroy Qty = 1 + Repair D3589-3 B 78463 Qty D3589-7 B 46124 Qty	11-10-25	S 11/10/25	S QS7042 11/10/25	S 11/10/25
				in form welds to Databk check All work before final welds.		S 11/10/25		

NOTE: Date & initial all entries

Work Order ID 68855

Thursday, April 21, 2011 12:36:13 PM

Page 2

Item ID: D3589-041

Accept

Setup Start

Revision ID:

Stop

Item Name: LATCH ASSEMBLY

Start Date: 4/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:




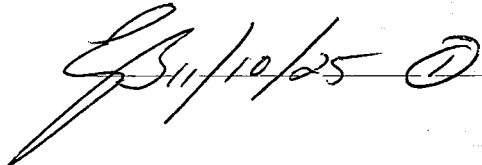


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 u10105					
130  Small Fab Small Fab	1- Assemble as per dwg Memo	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 u10106					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68855

Thursday, April 21, 2011 12:36:13 PM



Page 3

Item ID: D3589-041

Accept



Setup Start



Revision ID:

Stop



Item Name: LATCH ASSEMBLY

Start Date: 4/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PM 75504</i>	0.00 0.00						<i>11/10/26</i>	<i>(Signature)</i>
160 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>11/10/26</i>	<i>(Signature)</i>
Quality Control								<i>MF</i> <i>11-10-26</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:36:10 PM

Page 1

Work Order ID: 68855

Parent Item: D3589-041

Parent Item Name: LATCH ASSEMBLY



Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise
process as per coss DD 10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-1 ARM		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				1					
				67083				1					
D3589-11 FWD GUIDE PLATE		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				5					
				56928				5					
D3589-13 LUG		Manufactured	No			100	Each	13.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				13					
				68199				13					
D3589-3 ARM GUIDE		Manufactured	No			100	Each	0.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				13					
				68199				13					
D3589-7 AFT GUIDE PLATE		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA023				5					
				46194				5					

73463 x5

EL 11-10-25

EL 11-10-25

EL 11-10-25

EL 11-10-25

EL 11-10-25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:36:10 PM

Work Order ID: 68855

Parent Item: D3589-041

Parent Item Name: LATCH ASSEMBLY

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3589-9 Manufactured No

100 Each

8.0000

1

1



FWD GUIDE PLATE



EL 11/10/25

Location

Loc Qty

Loc Code

WA023

8

67975

8

130

Each

1,153.000

4

4

AN960JD4 NAS1149DN432J Purchased No



Washer

LD M117460 (42)



11/10/25

Location

Loc Qty

Loc Code

ST346

1153

11735

722

7636

431

130

Each

1.0000

2

2

D3589-15 Manufactured No



LINK



11/10/25

Location

Loc Qty

Loc Code

WA023

1

67134

1

130

Each

8.0000

2

2

MS20392-1G7 Purchased No



Pin



11/10/25

Location

Loc Qty

Loc Code

ST315

8

108521

8

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:36:10 PM

Page 3

Work Order ID: 68855

Parent Item: D3589-041

Parent Item Name: LATCH ASSEMBLY

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-1010

Purchased

No

130

Each

377.0000

2

2



COTTER PIN



Location

Loc Qty

Loc Code

ST309

377

108335

200

114405

177

Handwritten signature
4/21/10/25
2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

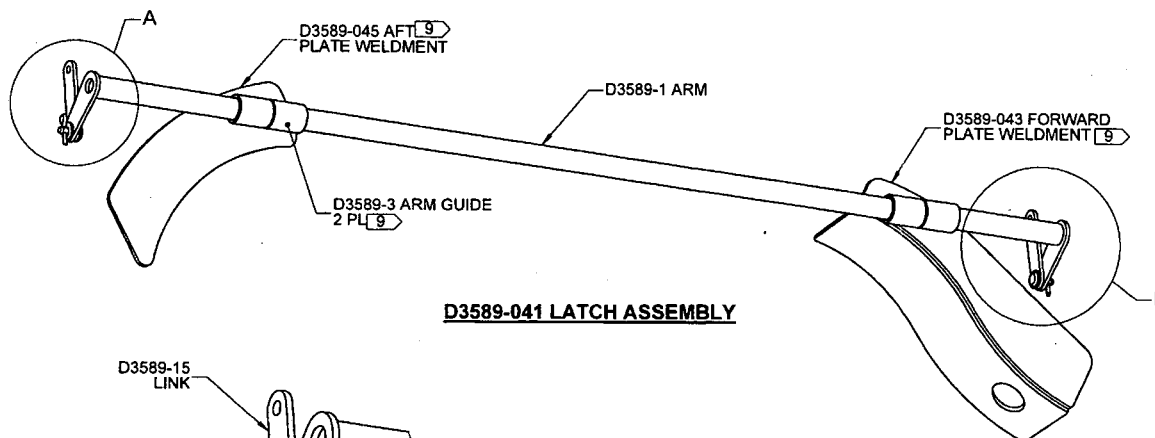
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

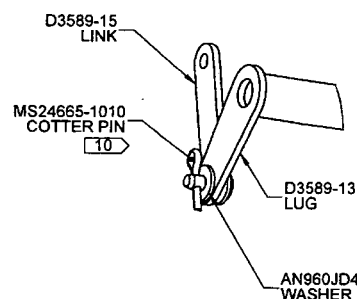
NOTE: Date & initial all entries

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4885
PL 11-04-21

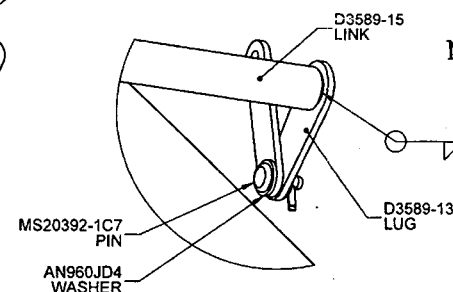


D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL

SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**

SCALE 2X
2 PL

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.80 AND 0.83 REF WERE 1.97 AND 0.80 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29 WAS 15 (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.25		

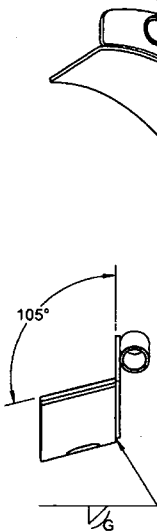
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA.

DRAWING NO.
D3589
REV. B
SHEET 1 OF 8
TITLE
LATCH ASSEMBLY
SCALE
NTS

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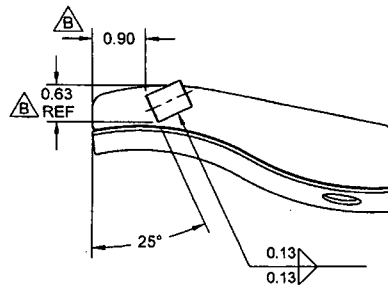
QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE

D3589-3
ARM GUIDE

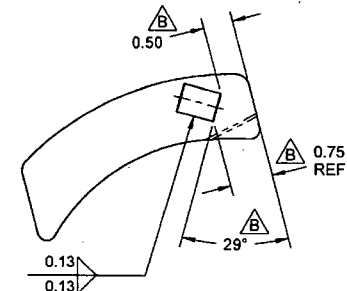
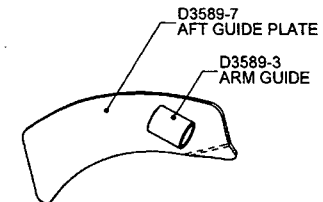


D3589-9
FORWARD GUIDE PLATE

D3589-11 [9]
FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

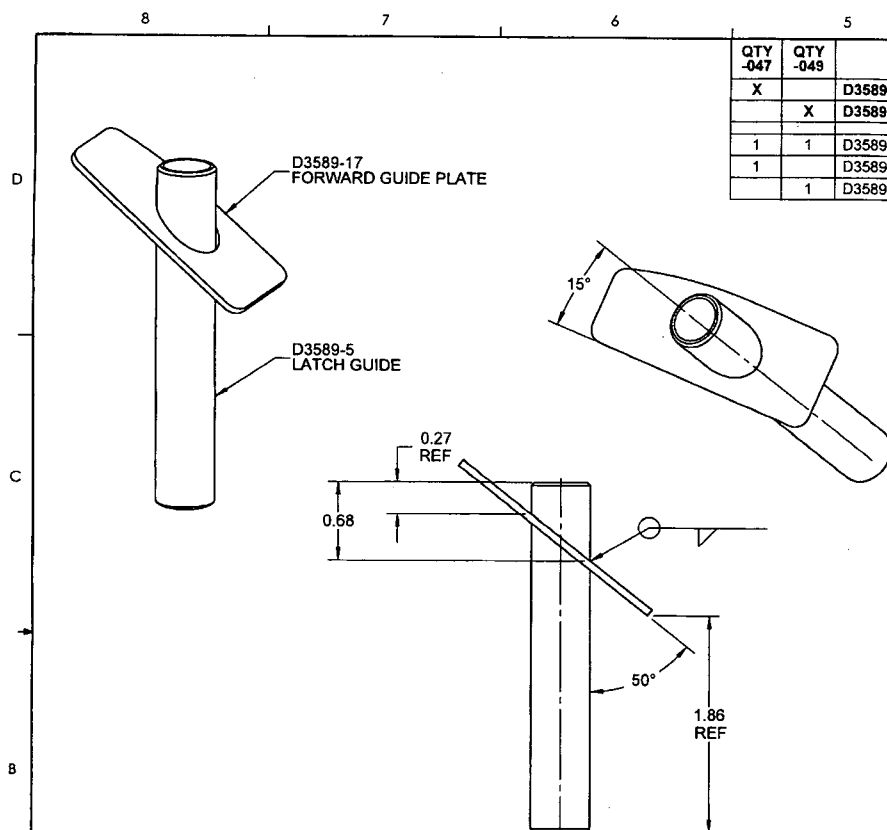
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

w/068855

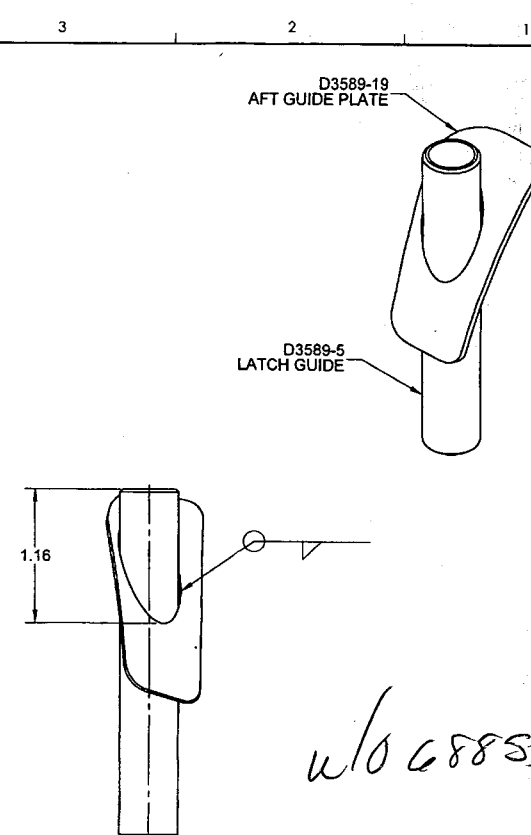
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8/10/05 N/A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3589 TITLE LATCH ASSEMBLY DATE 08.06.25	REV. B
DRAWN			SHEET 2 OF 8
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -047	QTY -049	P/N	DESCRIPTION
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE



D3589-047 FORWARD GUIDE



D3589-049 AFT GUIDE

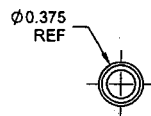
w/o 68855

RELEASED
09/06/08

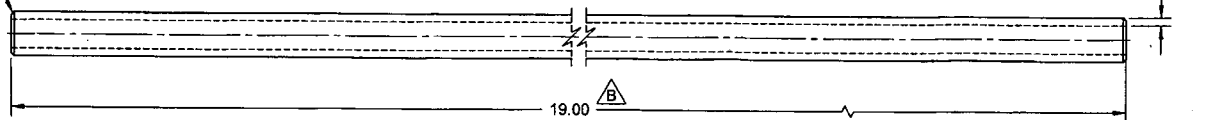
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DRAWN	<i>[Signature]</i>		SHEET 3 OF 8
CHECKED	<i>[Signature]</i>	DRAWING NO. D3589	SCALE NTS
MFG. APPR.	<i>[Signature]</i>	TITLE LATCH ASSEMBLY	
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>	DATE 08.06.25	

D3589-047/-049 NOTES:

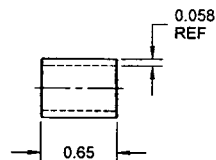
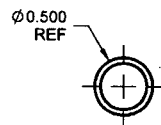
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004



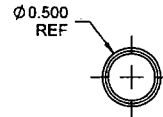
0.03 X 45°
CHAMFER
2 PL



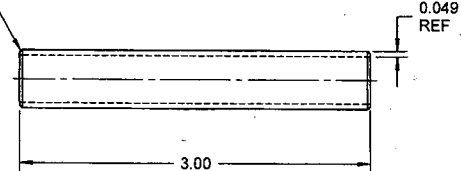
D3589-1 ARM



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



D3589-5 LATCH GUIDE

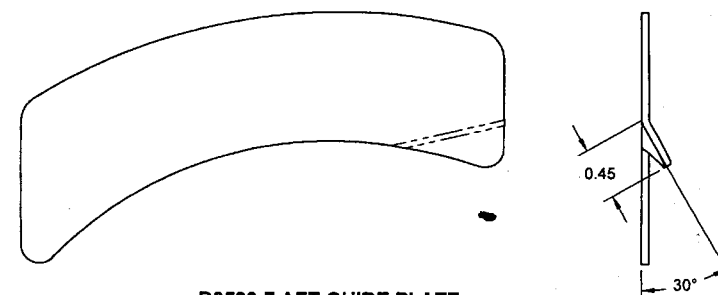
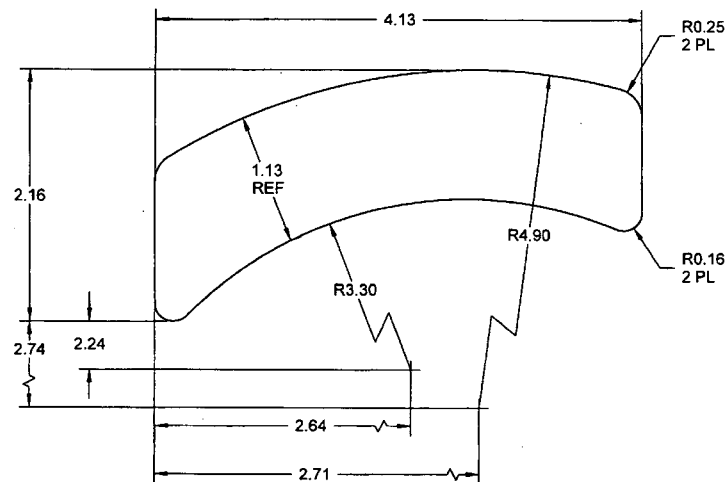
D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

W1068855

RELEASED
09/02/05

DESIGN	<i>J</i>	DART AEROSPACE LTD	
DRAWN	<i>J</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV: B
MFG. APPR.	<i>DS</i>	D3589	SHEET 4 OF 8
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>HT</i>	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

D3589-7F AFT GUIDE PLATE
FLAT PATTERN

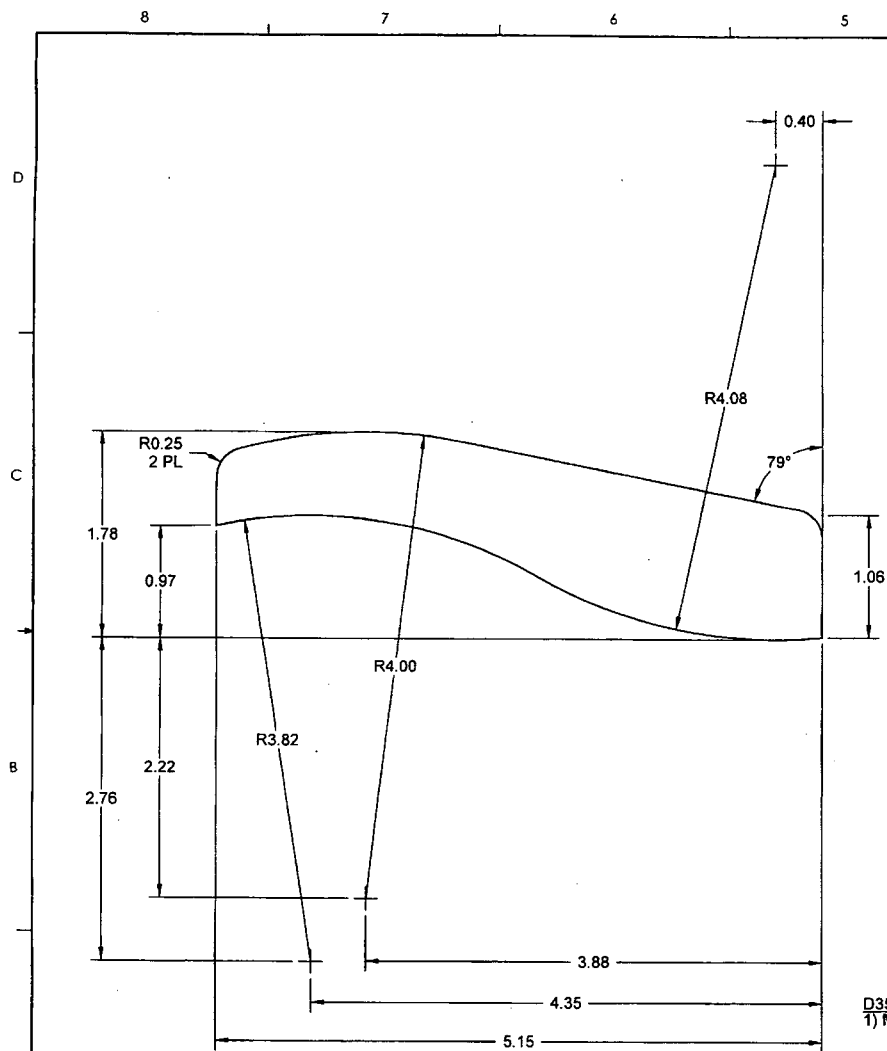
W/O 68855

RELEASED
09/25/05 MB

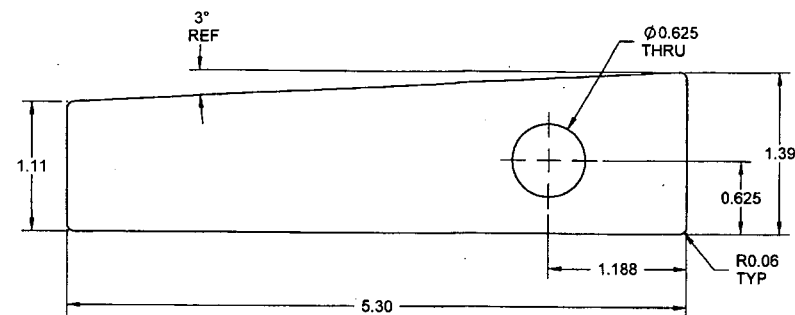
D3589-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

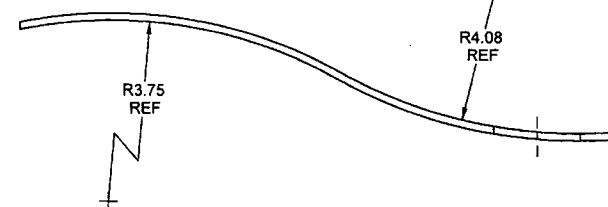
DESIGN	<i>JA</i>	DART AEROSPACE LTD	
DRAWN	<i>JA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. D3589	REV. B
MFG. APPR.	<i>RS</i>		SHEET 5 OF 8
APPROVED	<i>JO</i>	TITLE LATCH ASSEMBLY	SCALE
DE APPR.	<i>JA</i>		NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



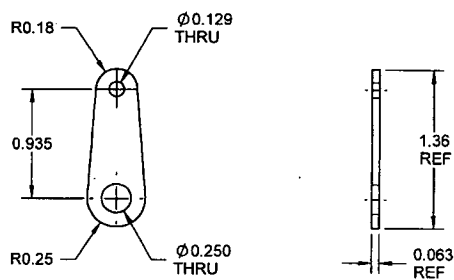
D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

D3589-9/-11/-11F NOTES:

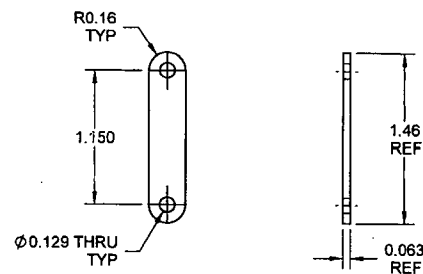
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK),
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

RELEASED
09/22/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3589-13 LUG



D3589-15 LINK

w/o 68855

RELEASED
09/02/05 NTS

D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

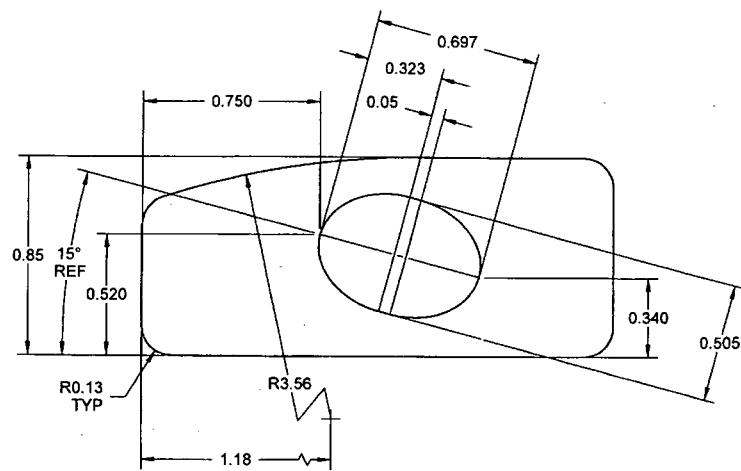
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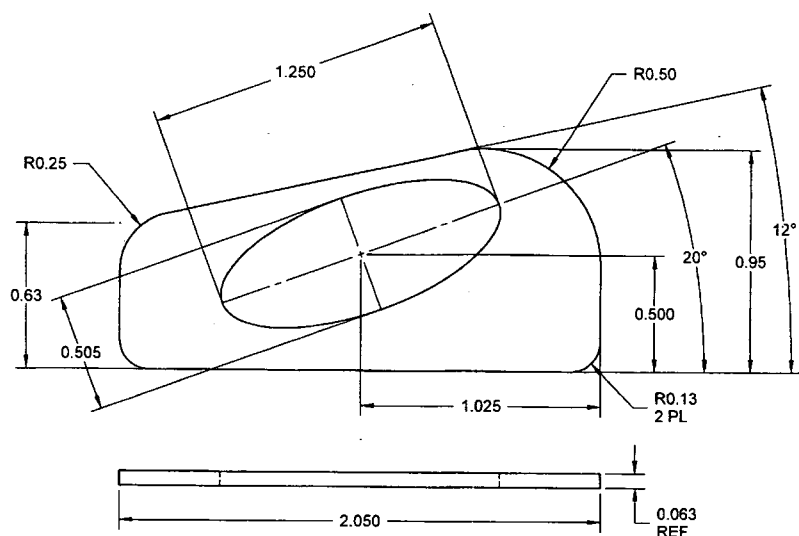
C

B

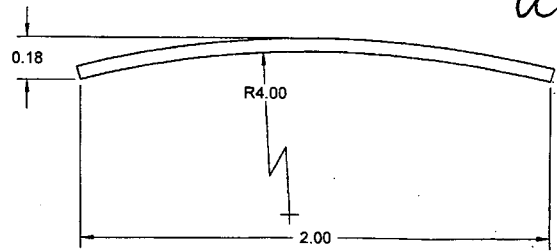
A



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/6/05/11/17

- D3589-17/-19/-19F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs EACH

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1